

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010816**Date Inspected:** 04-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Panels**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

QA Inspeotr performed conventional Ultrasonic Testing (UT) of U-rib continuity plate welds and splice weld to the requirements of AWS D1.5;2002. Welds tested and results of testing are as follows:

DP3043-001 Welds 066, 067, 076, 077; 15% UT-Tested.

DP3015-001 Welds 123, 124, 081, 082, 133, 134, 143, 144, 153, 154; 15% UT-Tested.

DP3007-001 Weld 025; 15% UT-Tested.

QA Inspector performed Final Visual Inspection (VT) following the guide lines of AWS-D1.5 on Deck Panel assemblies including Partial Penetration (PJP) welds joining U-ribs to deck plate. The deck panels examined are as follows:

DP323-001: Final VT appears to comply with code and contract requirements.

DP426-001: Final VT appears to comply with code and contract requirements.

QA Inspector performed QA Verification Magnetic Particle Testing (MT) on U-rib deck panel assemblies following the guidelines of Caltrop MT Procedure CTMT-08-00 Rev. 2.1. Deck Panels Inspected and results are as follows:

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DP323-001: 15% MT-Tested.

DP426-001: 15% MT-Tested.

QA Inspector worked on Document Control for U-rib deck panels. Deck panel Phased Array Ultrasonic Testing (PAUT) reports input and updated for lift 10 and 11 deck panels. Deck panel PAUT reports organized and copied for transmittal and summary update. Deck panel log for lifts 10 and 11 deck panel assemblies updated and the Complete deck panel log updated.

QA Inspector continued organizing Deck Panel reports for archive. SMR deck panel summary spreadsheet reviewed and corrected. Began inputting information for the update of SMR deck panel record.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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